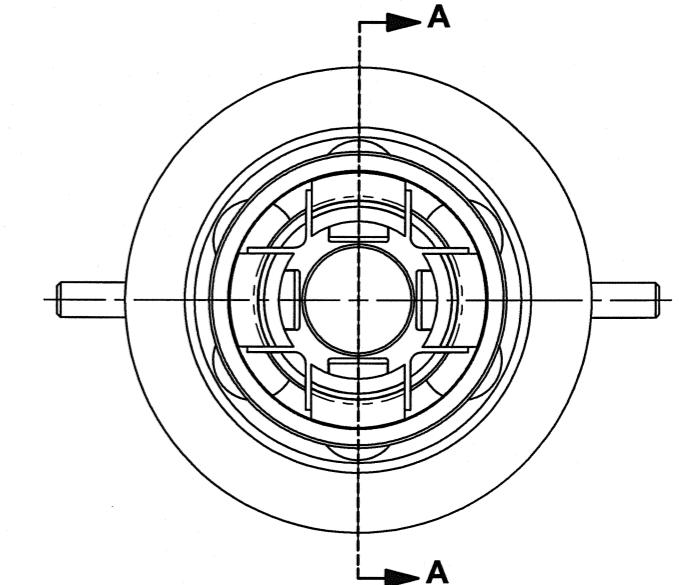
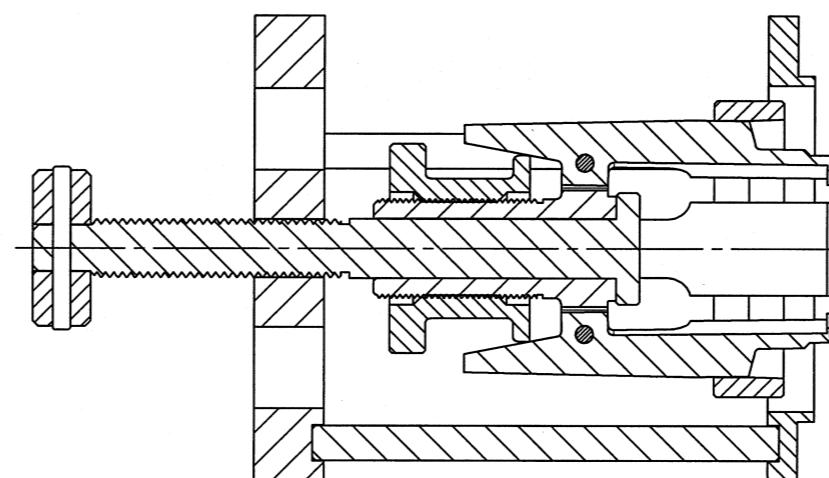
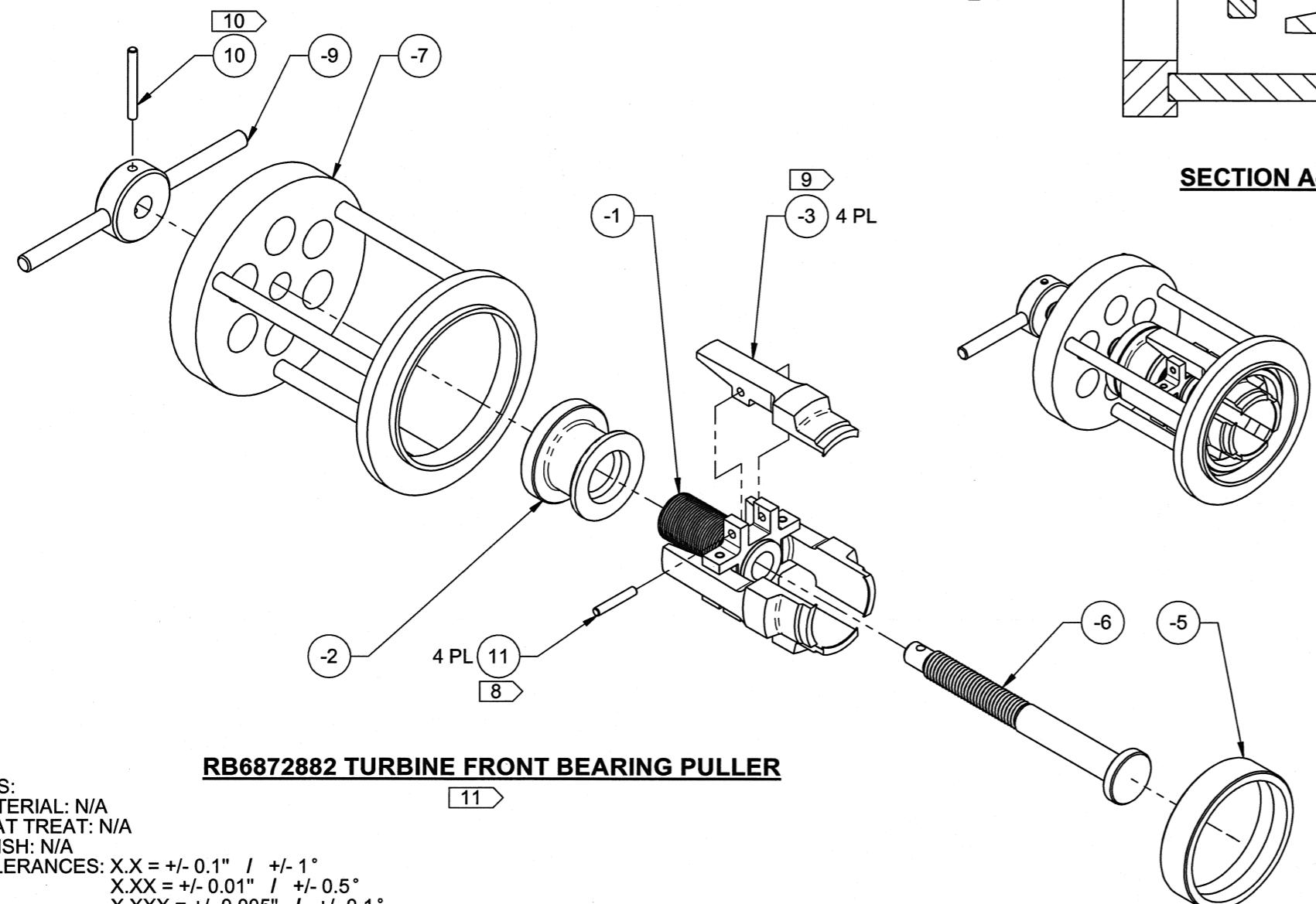


ITEM #	QTY	PART #	PART TITLE
-1	1	RB6872882-1	ADJUSTING SCREW
-2	1	RB6872882-2	ADJUSTING NUT
-3	4	RB6872882-3	FINGER
-5	1	RB6872882-5	RING
-6	1	RB6872882-6	JACK SCREW
-7	1	RB6872882-7	BODY WELDMENT
-9	1	RB6872882-9	HANDLE WELDMENT
10	1	McMaster#98381A515 OR EQUIV	STEEL DOWEL PIN 3/16" DIA. X 1-3/4" LG.
11	4	McMaster#98381A511 OR EQUIV	STEEL DOWEL PIN 3/16" DIA. X 1-1/8" LG.



SECTION A-A



RB6872882 TURBINE FRONT BEARING PULLER

11

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = $+\/-0.1"$ / $+\/-1^{\circ}$
X.XX = $+\/-0.01"$ / $+\/-0.5^{\circ}$
X.XXX = $+\/-0.005"$ / $+\/-0.1^{\circ}$
X.XXXX = $+\/-0.0005"$ / $+\/-0.05^{\circ}$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNL

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES

THEN PRESS FIT ITEM 11 WITH ITEM 1, AND REMOVE EXCESS
ITEM 9. MAKE MOVE FREELY BETWEEN GTS ITEM 1 AND AROUND ITEM 11 POWEL PIN AS SHOWN.

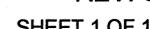
9) ITEM -3 MUST MOVE FREELY BETWEEN SLOTS OF ITEM -1 AND AROUND ITEM 11 DOWELL
10) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES

10) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 10 WITH ITEM 6 AND REMOVE EXCESS.

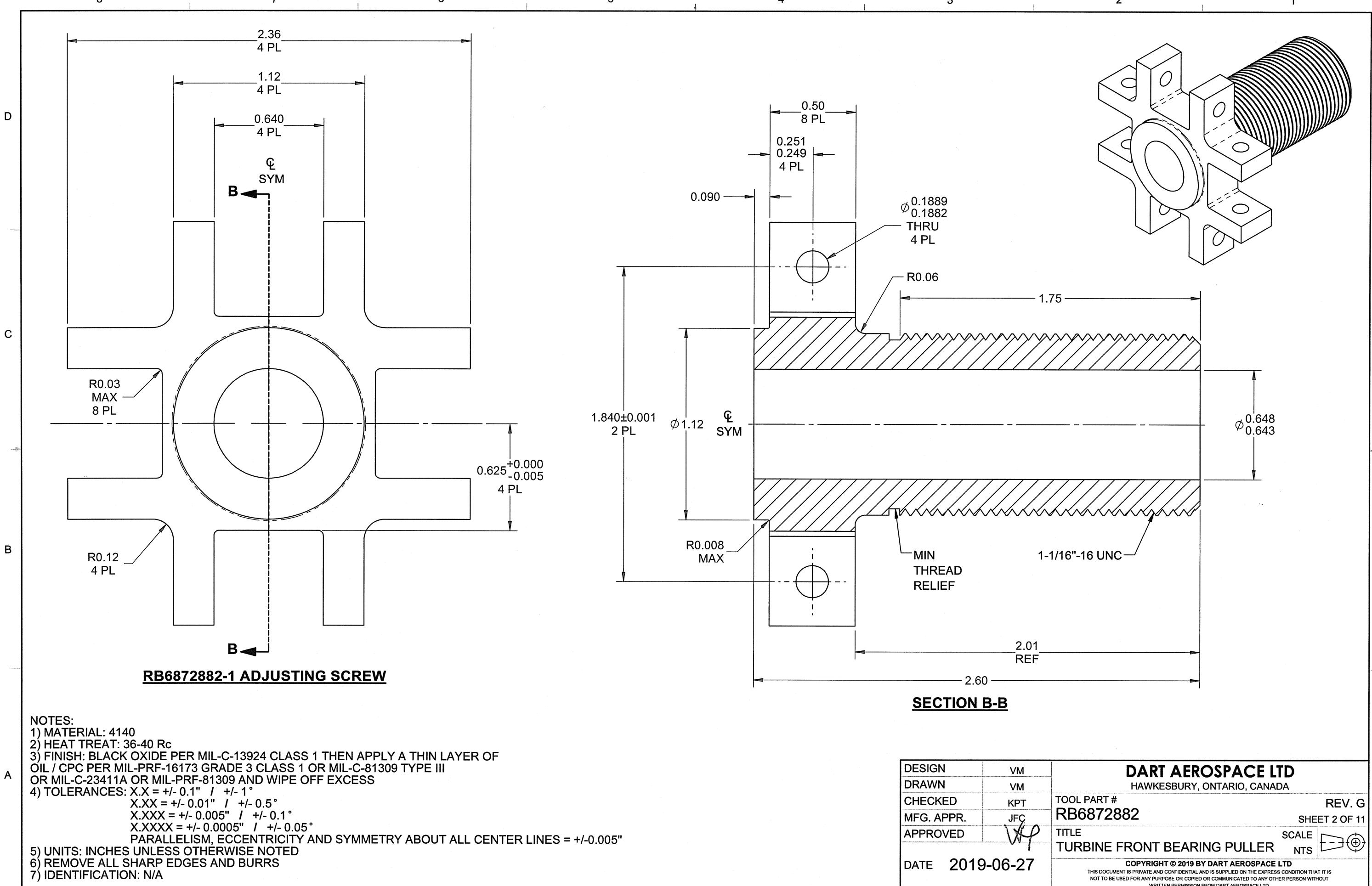
11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG.

11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SEE PREVIOUS PDFs FOR OLDER REVs
TEMPLATE UPDATED PER DART HBY STANDARDS
ITEM -4 CHANGED FOR ITEM 11
ITEM -7B REPLACED BY PURCHASE PART ITEM 12
McMaster#98381A644
ITEM -8 CHANGED FOR ITEM 10
ITEM -9A REPLACED BY PURCHASE PART ITEM 13
McMaster#98381A686
ITEM -1 DIMENSION 4X .625 CHANGED FOR 0.625 +/-0.005 4 PL,
DIMENSION 4X .920/.918 REPLACED BY 1.840 +/-0.001 2 PL,
DIMENSION R0.008 MAX ADDED, MATERIAL 4140/4142 RC 32-36
CHANGED FOR 4140 36-40 Rc
ITEM -2 DIMENSION 2X 60°/45° CHANGED FOR 0.07 X 45.0° CMF 2 PL,
MATERIAL BRASS CHANGED FOR BRASS 360
ITEM -3 DIMENSION .036/.032 CHANGED FOR 0.034 +/-0.002,
DIMENSION .625/.620 CHANGED FOR 0.625, DIMENSION .24
CHANGED FOR 0.238 +/-0.002, DIMENSION Ø.1874/.1871 CHANGED
FOR Ø.1875/.1867, DIMENSION Ø.2.062/2.060 CHANGED
FOR Ø.2.061 +/-0.001, DIMENSION .5 CHANGED FOR 0.50, MATERIAL
4140/4142 RC 36-40 CHANGED FOR O1 48-52 Rc, DIMENSION 0.708
ADDED
ITEM -5 MATERIAL 1018/1020 CR CHANGED FOR 1018/1020/1025 CR,
DIMENSION 1.78° REPLACED BY 3.56°, DIMENSION Ø2.776 CHANGED
FOR Ø2.776 REF
ITEM -6 MATERIAL 4140/4142 CHANGED FOR 4140, DIMENSION
Ø.5000/.4995 CHANGED FOR Ø.495 +/-0.005, DIMENSION .310
+.010/-0 CHANGED FOR .31+.01/-0, DIMENSION Ø.1874/.1871
CHANGED FOR Ø.1875/.1867, DIMENSION R0.008 MAX ADDED,
DIMENSION Ø.635 CHANGED FOR Ø.635 +/-0.005/-0
ITEM -7 GD&T TOLERANCES CORRECTED
ITEM -7A DIMENSION .17 CHANGED FOR 0.20, DIMENSION .50
CHANGED FOR 0.52 +/-0.01/-0
ITEM -7C MATERIAL 1018/1020 CR CHANGED FOR 1018/1020/1025
CR, ENGRAVING S/N AND "MADE IN USA" REMOVED
ITEM -9B MATERIAL 1018/1020 CR CHANGED FOR 4140 (28-32 Rc),
DIMENSION Ø.5011/.5004 CHANGED FOR Ø.500 +/-0.005/-0

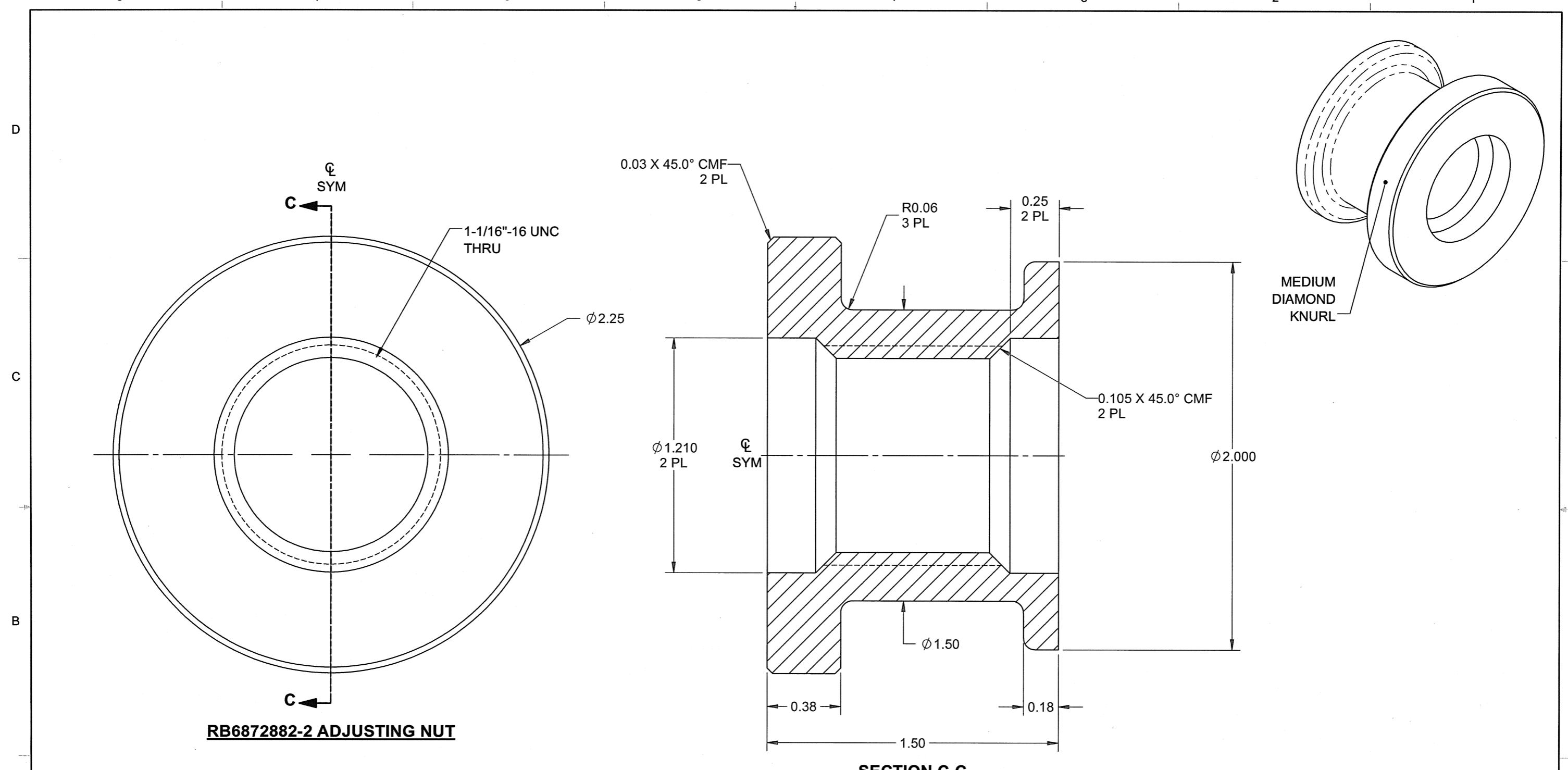
REV.	DESCRIPTION		ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VM			
CHECKED	KPT	TOOL PART #	REV. G	
MFG. APPR.	JFC	RB6872882	SHEET 1 OF 11	
APPROVED	<i>WJ</i>	TITLE	SCALE	
DATE	2019-06-27	TURBINE FRONT BEARING PULLER	NTS	
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DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	REV. G
MFG. APPR.	JFC	TOOL PART #
APPROVED	WP	RB6872882
		SHEET 2 OF 11
		TITLE
		TURBINE FRONT BEARING PULLER
DATE	2019-06-27	SCALE
		NTS

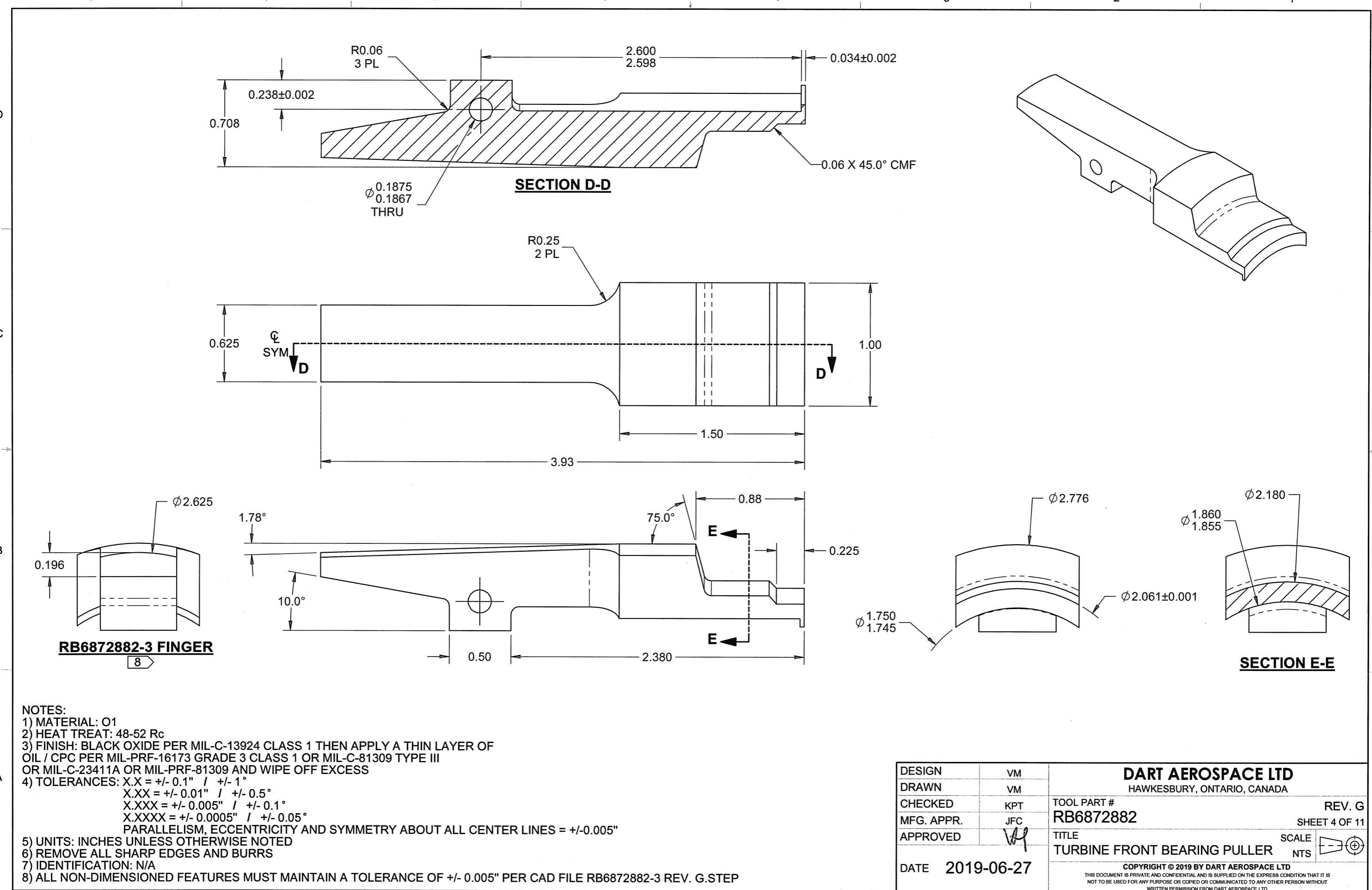
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**NOTES:**

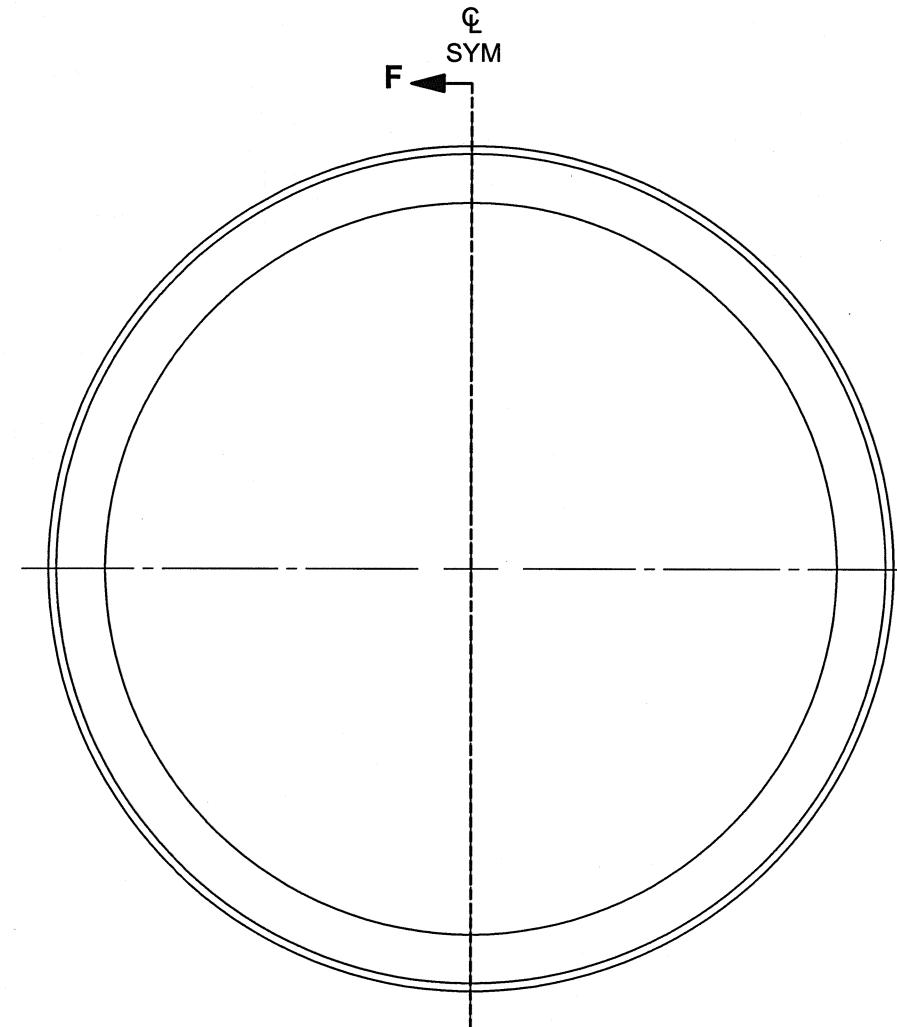
- 1) MATERIAL: BRASS 360
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
 $X.XX = $+\/- 0.01"$ / $+\/- 0.5^\circ$$
 $X.XXX = $+\/- 0.005"$ / $+\/- 0.1^\circ$$
 $X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^\circ$$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	WJ		
TOOL PART #	RB6872882	REV. G	
TITLE	TURBINE FRONT BEARING PULLER		
SCALE	NTS		
DATE	2019-06-27		

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D

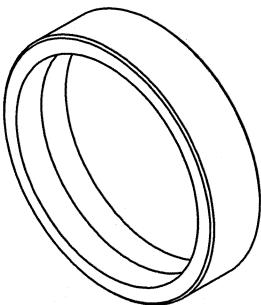
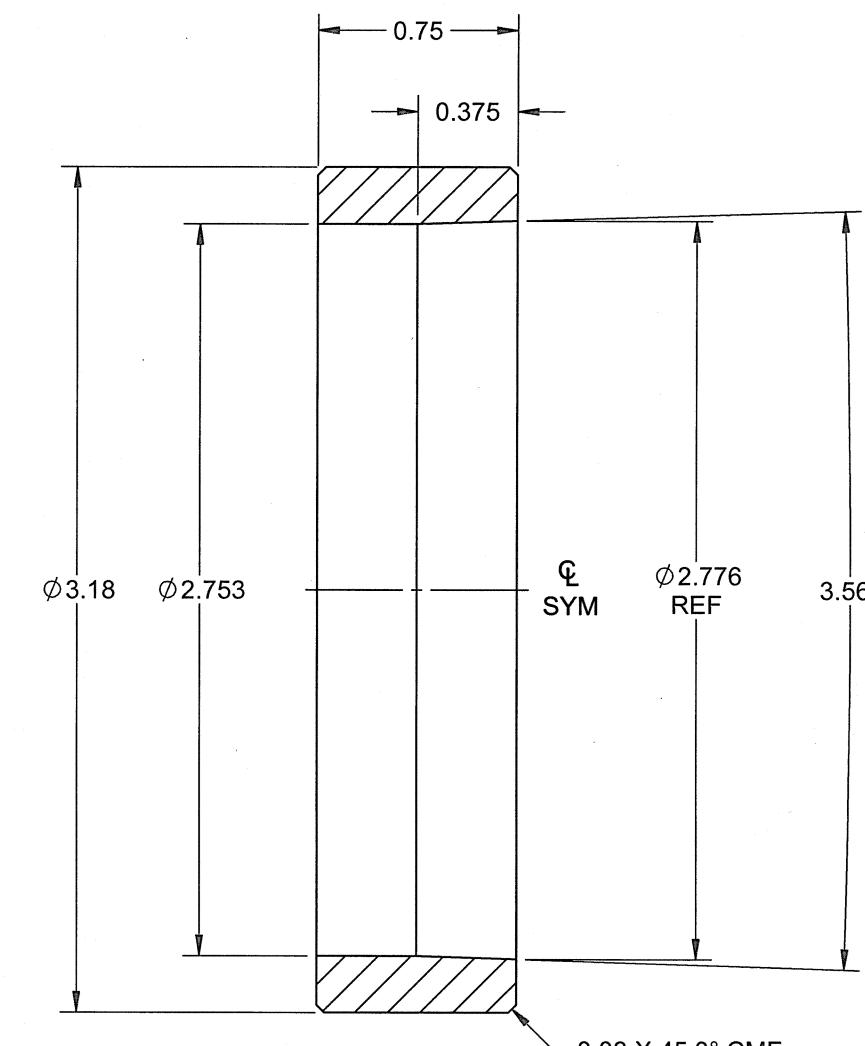


A

B

C

D



NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	JFC	RB6872882	
APPROVED	WJ	REV. G	
TITLE		SHEET 5 OF 11	
TURBINE FRONT BEARING PULLER		SCALE	NTS
DATE 2019-06-27		COPYRIGHT © 2019 BY DART AEROSPACE LTD	

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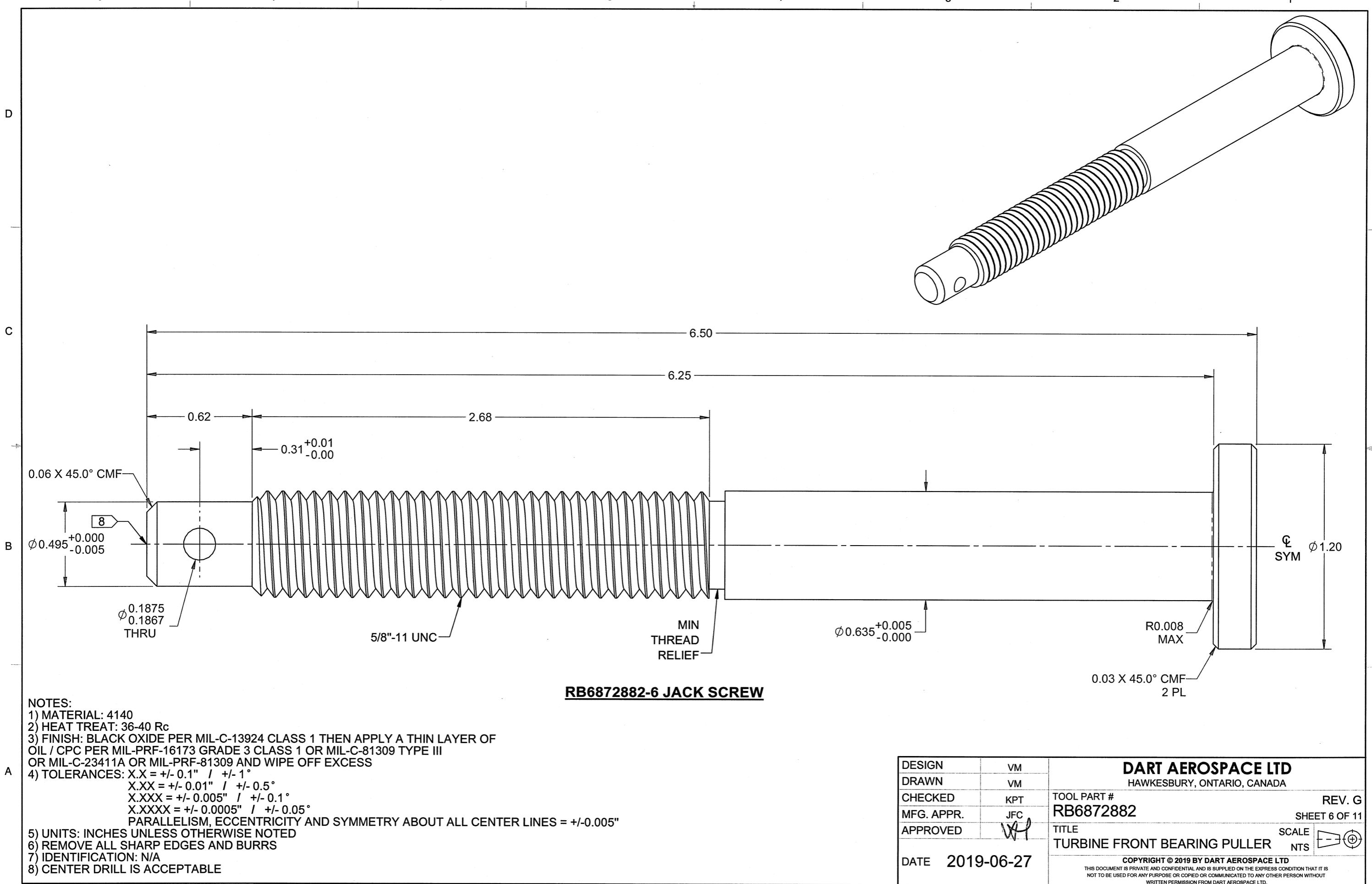
D

C

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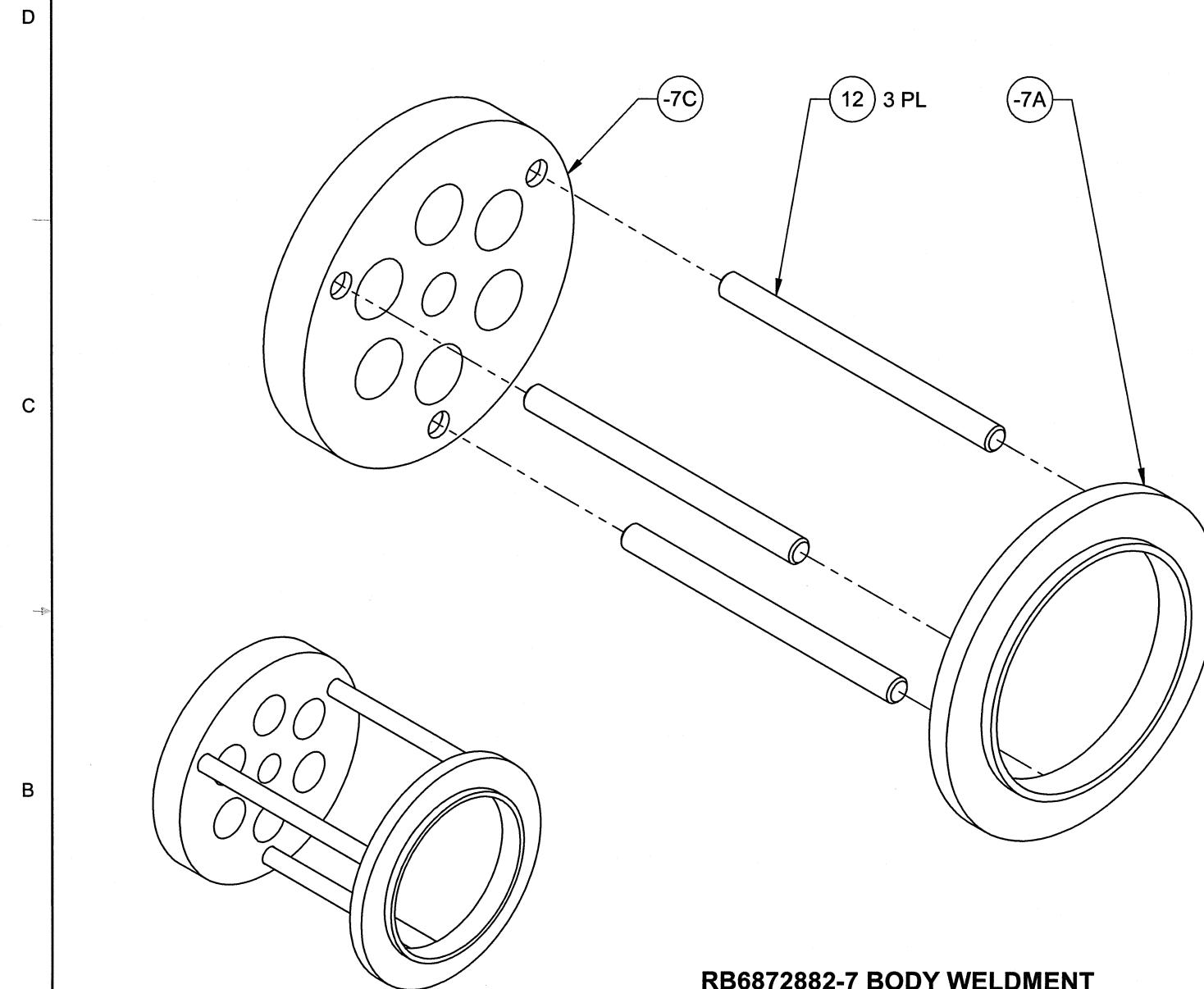
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DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	JFC	RB6872882	
APPROVED	<i>W</i>	REV. G	
TITLE		SHEET 6 OF 11	
TURBINE FRONT BEARING PULLER		SCALE	NTS
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DATE 2019-06-27

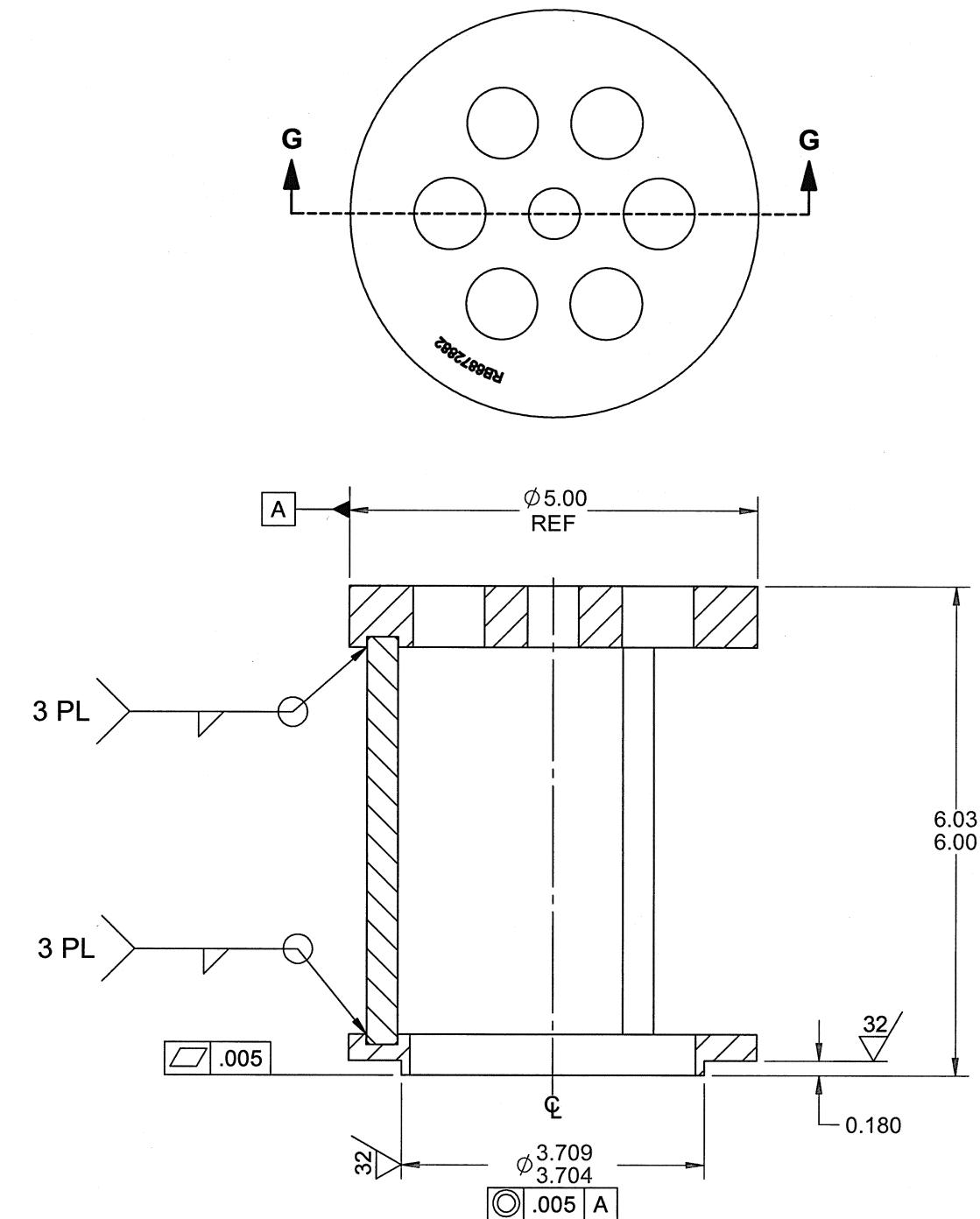
ITEM #	QTY	PART #	PART TITLE
-7A	1	RB6872882-7A	BODY BOTTOM
-7C	1	RB6872882-7C	BODY TOP
12	3	McMaster#98381A644 OR EQUIV	STEEL DOWEL PIN 3/8" DIA. X 5" LG.



RB6872882-7 BODY WELDMENT

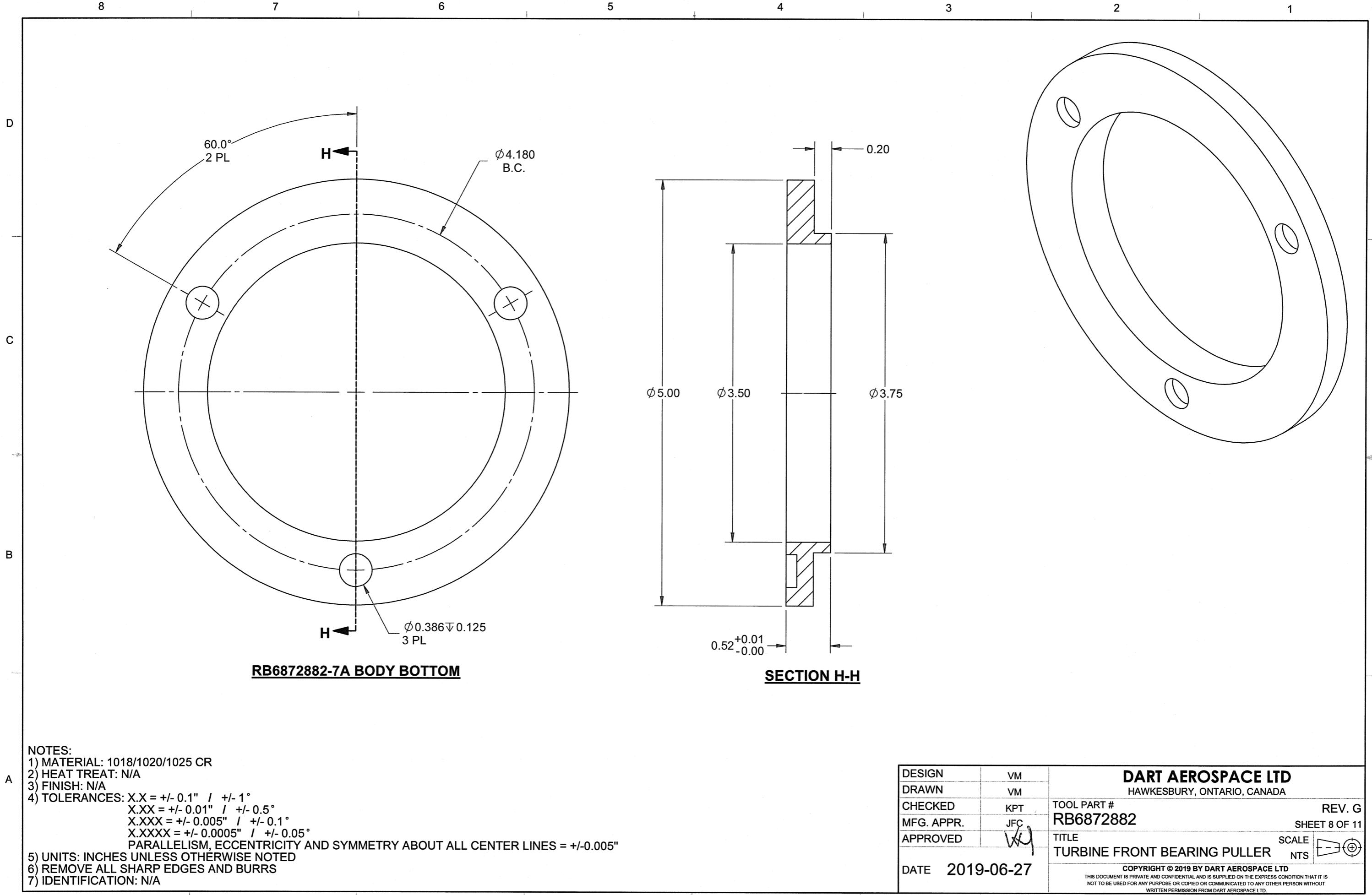
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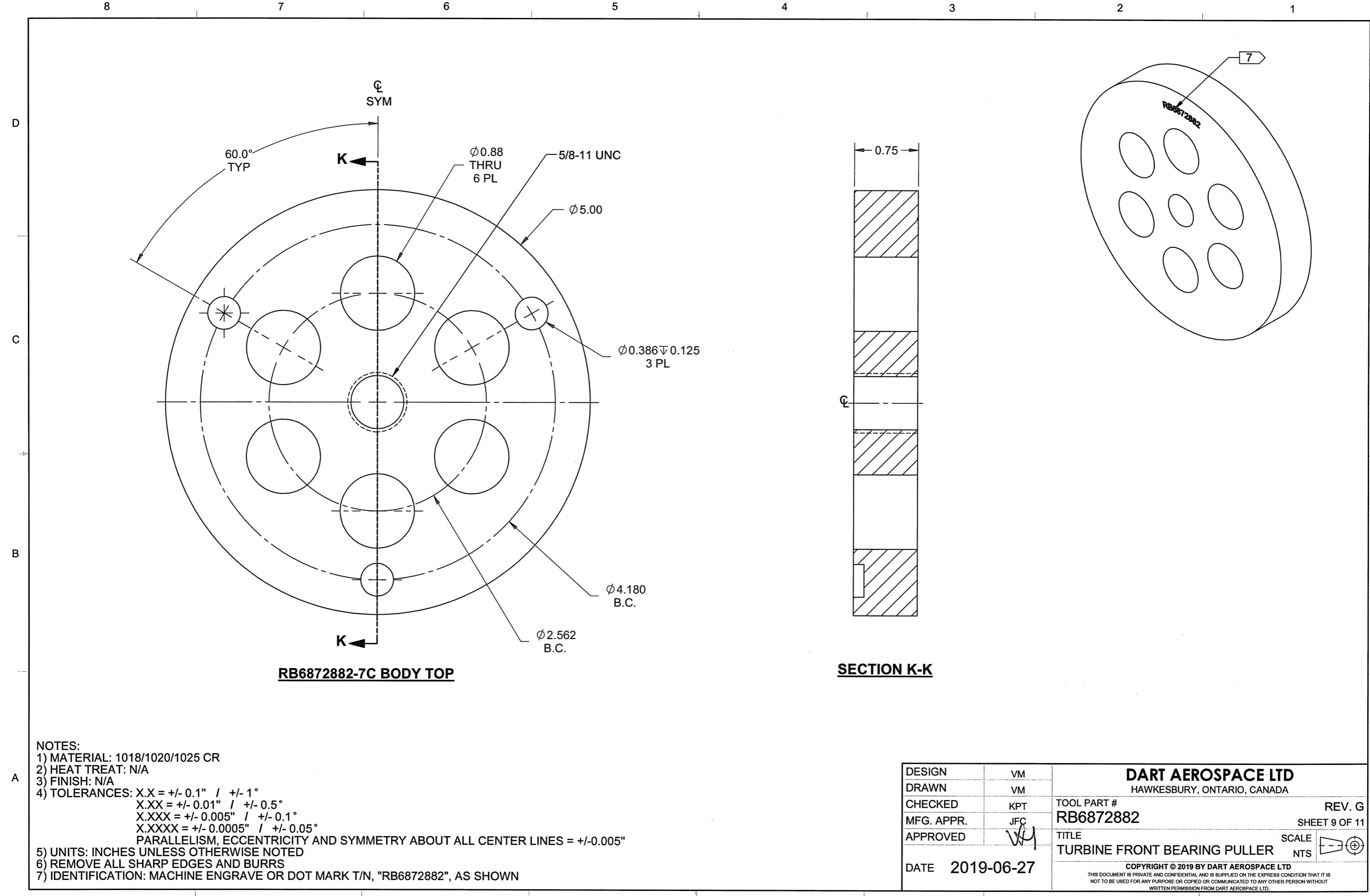
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS



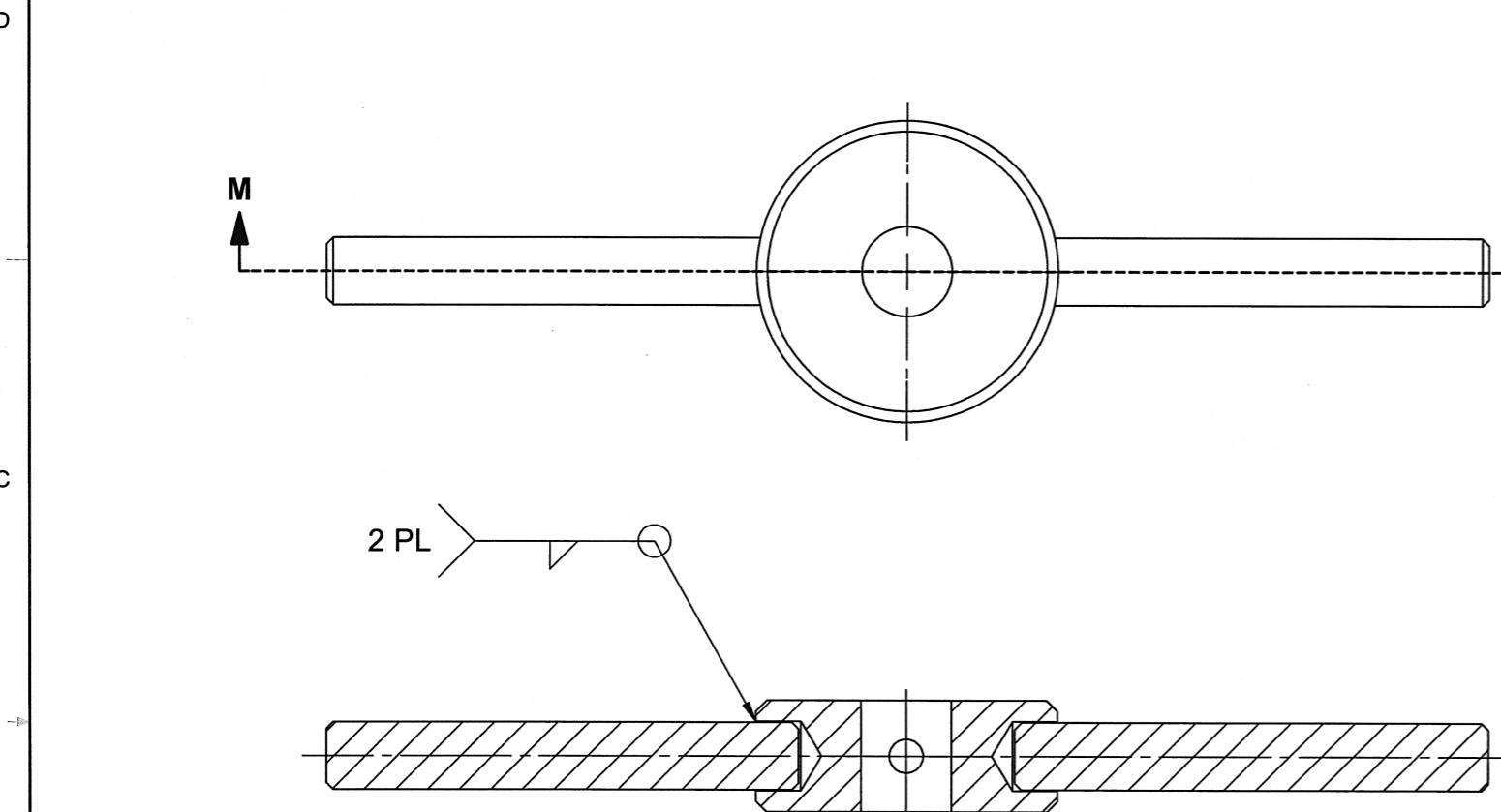
SECTION G-G

DESIGN DRAWN	VM	DART AEROSPACE LTD	
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	KPT	REV. G	TOOL PART #
APPROVED	JFC	RB6872882	SHEET 7 OF 11
DATE 2019-06-27		TITLE TURBINE FRONT BEARING PULLER	
SCALE			
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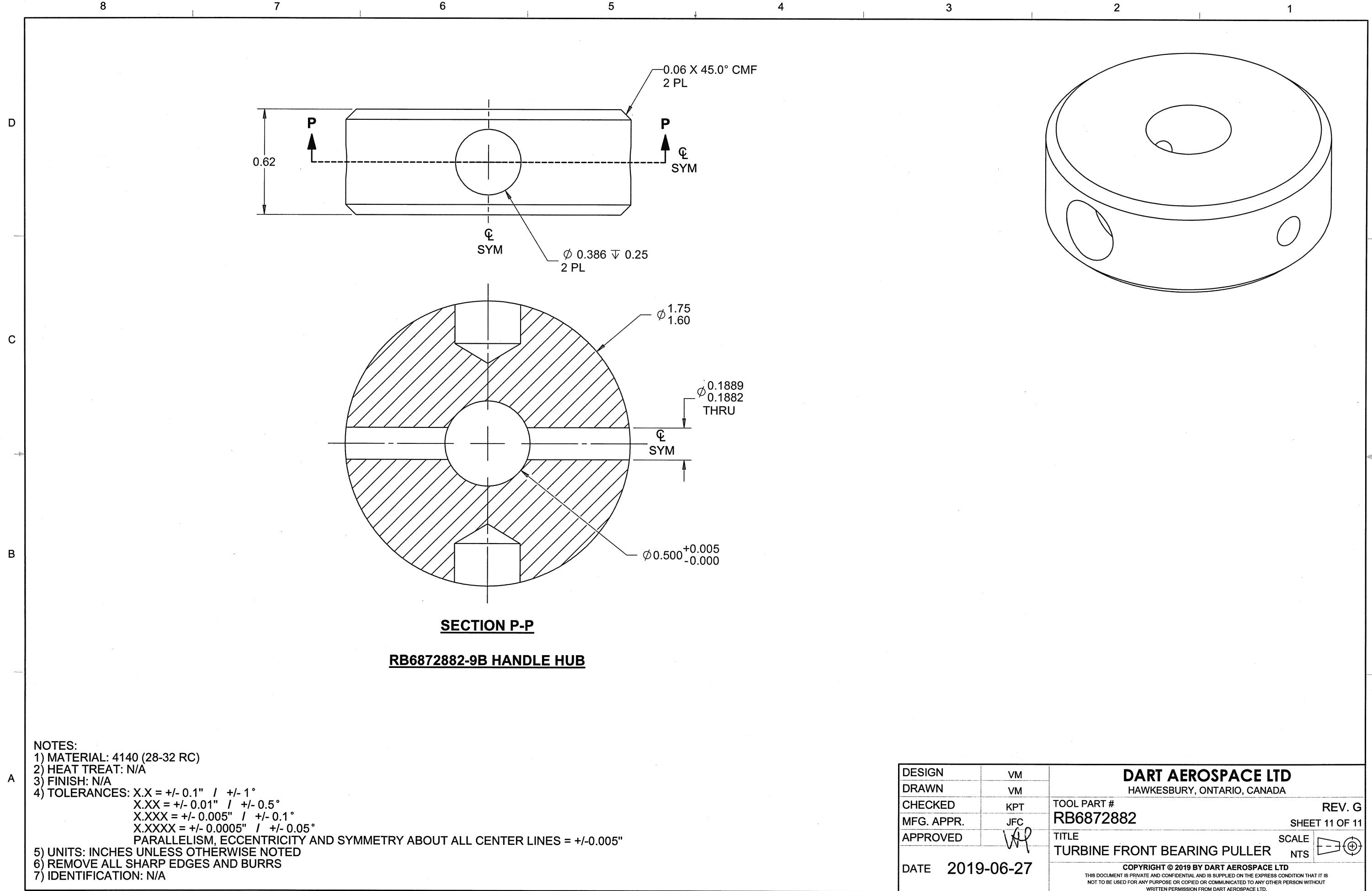
ITEM #	QTY	PART #	PART TITLE
-9B	1	RB6872882-9B	HANDLE HUB
13	2	McMaster#98381A686 OR EQUIV	STEEL DOWEL PIN 3/8" DIA. X 2-5/8" LG.

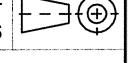
**SECTION M-M****RB6872882-9 HANDLE WELDMENT****NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	KPT	TOOL PART #	RB6872882
MFG. APPR.	JFC	REV. G	SHEET 10 OF 11
APPROVED	<i>[Signature]</i>	TITLE TURBINE FRONT BEARING PULLER	
DATE 2019-06-27		SCALE	NTS

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DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	JFC		
APPROVED	<i>WJ</i>		
TOOL PART #	RB6872882		REV. G
			SHEET 11 OF 11
TITLE	TURBINE FRONT BEARING PULLER		SCALE  NTS
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